Work Order ID 112750

Thursday, February 06, 2014 12:40:19 PM

112750

Feb 24th

Item ID: PB67-43001-205 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Outer Tube

Start Date: 2/6/2014 **Start Qty:** 6.00 *6*

Required Date: 2/20/2014 **Req'd Qty:** 6.00 *6*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MF **Date:** 14-2-6 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Draw Nbr	Revision Nbr
B67-43001	C

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100		0.00							
100	BAND SAW								
Bandsaw	**Memo**	0.00							JFC 2014-02-08
Jeaspa Bandsaw	1- cut to length as per dwg 2-cut a angle on one end of tube as per dwg 3- deburr								MH 14-02-05
110		0.00							
110	CONVENTIONAL MILLING MACHINE								
Mill Conv	**Memo**	0.00							JFC 2014-02-09
Conventional Milling Machine	1- drill holes and mill slot as per dwg PB67-43001 USE DT8792 2- deburr								MH 14-02-15
120	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
120						(6)	14-03-11		
QC	**Memo**	0.00							
Quality Control									

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: [signature] Date: 14/05/08

QA Closed: [signature] Date: 14/5/20

Work Order: 112750

Part No. PB67-43001-205

NCR No. NCRA-3876

DISPOSITION

Rework	✓
Scrap	
Use-as-is	
Work Order Update	

AGAINST DEPARTMENT/PROCESS

Skid-tube		Crosstube		Water Jet		Engineering	
Machining	X	Small Fab		Prod. Eng. Coor.		Quality	
Thermoforming		Finishing		Rec/Store/Packaging		Other	
Large Fab		Composite		Supplier			

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling										
Operator	X	2014-02-08	110	2x	more hole in part. PR	14.02.10	PLUG W/WELD + BUFF SMOOTH. NO BUFFING INSIDE TUBING AT SLOT LOCATION.	2014-02-08 JFC 14-03-11	DAS 9 9-89 14.03-11	DAS 27 9-89 14/3/11
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										

FAULT CATEGORY

Landing Gear

- [ ] Bending
- [ ] Centre Not Concentric to O/S
- [ ] Cracks
- [ ] Crushed/Crimped
- [ ] Cuffs
- [ ] Heat Treat
- [ ] Inspection Strip in Tube
- [ ] Ripples in Bend
- [ ] Torque Waves in Extrusion
- [ ] Turning Sequence
- [ ] Wave/Twist in Tube

General

- [ ] Bend
- [ ] BOM/Route
- [ ] Broken/Damaged
- [ ] Burrs
- [ ] Contamination
- [ ] Countersink
- [ ] Cut Too Short
- [ ] Drill Holes
- [ ] Drawing
- [ ] Finish
- [ ] Folio
- [ ] Grain
- [ ] Hardware
- [ ] Inspection Incomplete
- [ ] Instructions Incomplete/Unclear
- [ ] Maintenance
- [ ] Mislabeled
- [ ] Misread
- [ ] Offset
- [ ] Out of Calibration
- [ ] Out of Sequence
- [ ] Outside Dimensions
- [ ] Ovalized
- [ ] Over/Under tolerance
- [ ] Part Incorrect
- [ ] Part Lost/Missing
- [ ] Part Moved
- [ ] Positioned Wrong
- [ ] Power Loss/Surge
- [ ] Pressure/Forced
- [ ] Temperature/Cure
- [ ] Weld
- [ ] Wrong Stock Pulled
- [ ] Other

Item ID: PB67-43001-205 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Outer Tube
Start Date: 2/6/2014 **Start Qty:** 6.00 *6*
Required Date: 2/20/2014 **Req'd Qty:** 6.00 *6*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Weld per dwg A/R Aluminum rod Batch: HD5091	0.00							
130	Large Fab								
Large Fab	**Memo**	0.00				(6)	14-03-11		AD
Large Fab	1-Weld end cap as per dwg PB67-43001 2-grind end cap flush								P/O →
140	QC10- Inspect visual per QSI004- ground welds	0.00							
140									
QC	**Memo**	0.00				6	CL	14-3-10	
Quality Control									
		DAS 27 9-89							
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	**Memo**	0.00 14/3/10				6			
Quality Control									

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: [signature] Date: 14/05/16

QA Closed: [signature] Date: 14/5/8

Work Order: 112750

Part No. PB 67-43001-205

NCR No. 14-3829

DISPOSITION

- Rework [X]
- Scrap [X]
- Use-as-is [X]
- Work Order Update [ ]

AGAINST DEPARTMENT/PROCESS

Skid-tube	[ ]	Crosstube	[ ]	Water Jet	[ ]	Engineering	[ ]
Machining	[ ]	Small Fab	[ ]	Prod. Eng. Coor.	[ ]	Quality	[ ]
Thermoforming	[ ]	Finishing	[ ]	Rec/Store/Packaging	[ ]	Other	[ ]
Large Fab	[X]	Composite	[ ]	Supplier	[ ]		[ ]

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data [ ] Equip/Tooling [ ] Operator [ ] Material [ ] Setup [ ] Other [ ] Process [ ] Supplier [ ] Training [ ] Unapproved [ ]	14/03/10	# 110	x1	Found on tube @ inspection small kink/Dent on out side of tube. at 20"-21" From Eng RC. miss handling of material. (thin mat Dents Easily on Rack) operator Error.	QS 1042 14.03.11	ACCEPTABLE DEVIATION AS LONG AS NOT APPARENT.	PD 14.03.11	DAS 16 9-89 14/03/13	DAS 16 9-89 14/03/13

FAULT CATEGORY

Landing Gear	General			
[ ] Bending	[ ] Bend	[ ] Grain	[ ] Ovalized	[ ] Pressure/Forced
[ ] Centre Not Concentric to O/S	[ ] BOM/Route	[ ] Hardware	[ ] Over/Under tolerance	[ ] Temperature/Cure
[ ] Cracks	[ ] Broken/Damaged	[ ] Inspection Incomplete	[ ] Part Incorrect	[ ] Weld
[ ] Crushed/Crimped.	[ ] Burrs	[ ] Instructions Incomplete/Unclear	[ ] Part Lost/Missing	[ ] Wrong Stock Pulled
[ ] Cuffs	[ ] Contamination	[ ] Maintenance	[ ] Part Moved	
[ ] Heat Treat	[ ] Countersink	[ ] Mislabeled	[ ] Positioned Wrong	
[ ] Inspection Strip in Tube	[ ] Cut Too Short	[ ] Misread	[ ] Power Loss/Surge	[X] Other
[ ] Ripples in Bend	[ ] Drill Holes	[ ] Offset	miss handling of Parts.	
[ ] Torque Waves in Extrusion	[ ] Drawing	[ ] Out of Calibration		
[ ] Turning Sequence	[ ] Finish	[ ] Out of Sequence		
[ ] Wave/Twist in Tube	[ ] Folio	[ ] Outside Dimensions		

Item ID: PB67-43001-205 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Outer Tube

Start Date: 2/6/2014 **Start Qty:** 6.00 *6*
Required Date: 2/20/2014 **Req'd Qty:** 6.00 *6*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location:_____	0.00							
160						14/3/12	(6)		DAS 32 ~~9-89~~
Packaging	**Memo** NR22	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170						MCJ 14-03-13			
QC	**Memo**	0.00							
Quality Control									

MCJ 14-03-13

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Picklist Print

Thursday, February 06, 2014 12:40:19 PM

1

Work Order ID: 112750

Parent Item: PB67-43001-205

Parent Item Name: Outer Tube

Start Date: 2/6/2014 **Required Date:** 2/20/2014

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP Rev:A 08-07-24 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.750W.065 6061T6 RDTUBE 1.750 X 0.65W		Purchased	No			100	f	163.0800	**3.615**	**23**			
				Location		**Loc Qty**		**Loc Code**					
				MAT016		163.08							
				110885		11.46							
				123485		15.2							
				M126139		64.42							
				M126183		72							
PB67-43001-199 Outer Tube End Cap		Manufactured	No			130	Each	8.0000	**1**	**6**			
				Location		**Loc Qty**		**Loc Code**					
				Mezz2		8							
				99985		8							

20.166 JFC 2014-02-08

11.46
8.706 JFC 2014-02-08

3.93 MH 14/02/05

B1141054 -> (6) M-03-10

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
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General

- ☐ Bend
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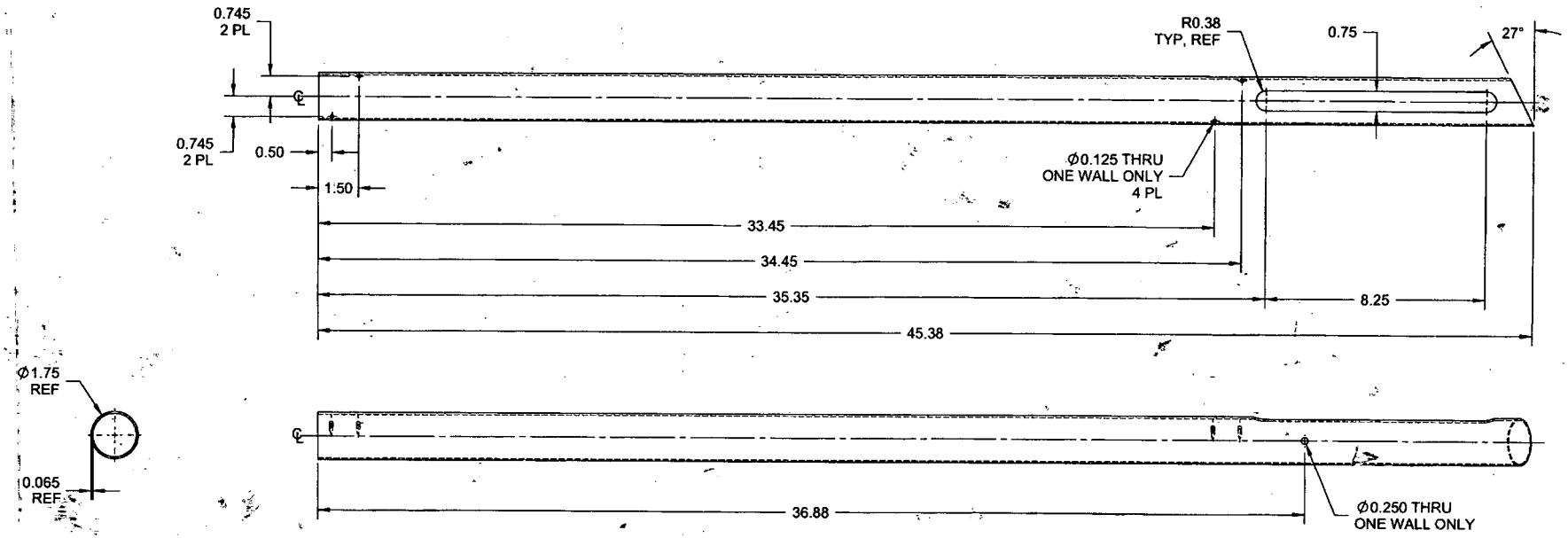
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

MF
#112750
14-2-6



B67-43001-205 OUTER TUBE

RELEASED
2009 -09- 24

NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING
PER WW-T-700/6 OR AMS4080 OR AMS 4082 OR
AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
REF. DART SPEC. M6061T6T1.750W.065
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.46 lbs

REV.	DESCRIPTION	BY	DATE
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISONS, REFER TO SHEET 16 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.02.27

DESIGN	RW	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. B67-43001-205 REV. C
MFG. APPR.		SHEET 1 OF 1
APPROVED		TITLE OUTER TUBE SCALE NTS
DE APPR.	N/A	
DATE	09.02.27	

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NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
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_____

_____

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